

Work Order ID 60411

July 7, 2010 10:29:16 AM



Page 1

Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 7/07/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 10/7/7 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2650	F
-------	---

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 , CHG003

N/A *AG*

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60411



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Page 2

Item ID: D206-642-341

Accept



Setup

Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 7/07/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod ☒ *M114242*
M112507

4-Grind weld flush to cap on top surface only.

5-Cut aft end to lenght as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

1

BE 10/07/08

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/6/07/08

Quality Control



120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00



10-7-12

Hand Finishing

125

QC3- Inspect Part Finish

0.00



QC

Memo

0.00



10/17/12

Quality Control

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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July 7, 2010 10:29:16 AM



Page 4

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Start Date: 7/07/10 Start Qty: 1.00

Required Date: 7/14/10 Req'd Qty: 1.00

Reference:

Accept

Cust Item ID:
Customer:

Setup

Start

Stop

Run

Start

Stop

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs.
cure time before cutting

Start Date: 10/07/13 Time: 1:30

Finish Date: 10/21/14 Time: 1:00 PM

A/R: Sikaflex-291 11/13/14

Sikaflex expiry date: 11/2010

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/07/14

(X)

BE 10/07/13

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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July 7, 2010 10:29:16 AM



Page 5

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Reference:

Accept



Setup

Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R ☐ Aluminum Rod M112507

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

4- Install nut plate as per dwg

X1

BE 10/07/15

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8.06/15

⊗

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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July 7, 2010 10:29:16 AM



Page 6

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

8/10/07/15

QC

Memo

0.00

Quality Control



190

Pressure Wash per QSI005 4.3

0.00

⇒ 10/07/16

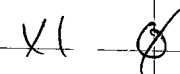
HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.



200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

12/14/841

Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:35
OVEN TEMPERATURE: 320°
FINISH TIME: 4:05

1 BR 10 719.

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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July 7, 2010 10:29:16 AM



Page 7

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Required Date: 7/14/10 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup

Start

Stop

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC3- Inspect Part Finish

0.00 => JJ

10/07/20

1

0

QC

Memo

0.00

Quality Control

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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July 7, 2010 10:29:16 AM



Page 8

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Accept



Setup

Start

Stop

Start Date: 7/07/10

Start Qty: 1.00



Required Date: 7/14/10

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



HandFinish

Hand Finishing

HandFinishing

0.00

0.00

Memo

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☐ M115114

Sikaflex expiry date: ☐ 11/01

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☐ M115114

Sikaflex expiry date: ☐ 11/01

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: M114432

10/07/20

1

0

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 60411

July 7, 2010 10:29:16 AM



Page 9

Item ID: D206-642-341

Accept



Setup

Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 7/07/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>M</i>	<i>10</i>	<i>07</i>	<i>20 (1)</i>
240 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>M</i>	<i>10</i>	<i>07</i>	<i>20 (1)</i>
250 Packaging Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D206-642-341 Location: _____ PPP Rev: _____	0.00 0.00							
						<i>10/7/30</i>		<i>52</i>	

PP

60596

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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July 7, 2010 10:29:16 AM



Page 10

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Revision ID:

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Cust Item ID:

Required Date: 7/14/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/30

10-7-30
①

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

July 7, 2010 10:29:15 AM

Page 1

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Parent Item Name: Replacement Skidtube

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DS19440 rev.a DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD416 Washer	NAS1149D0463J	Purchased	No				Each	20.0000	1	1			
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Location	Loc Qty	Loc Code
ST351	20	M115000
108827	20	

CCR264SS3-3 Cherry Rivet		Purchased	No				Each	544.0000	2	2			
-----------------------------	--	-----------	----	--	--	--	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST311	544	
112314	4	
113539	60	
113973	480	

CR3212-4-03 Cherry Rivet		Purchased	No				Each	3,745.000	2	2			
-----------------------------	--	-----------	----	--	--	--	------	-----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST311	3745	
111359	5	
112314	30	
114436	1142	
114450	568	
114859	2000	

M114889

12

BE 10/07/15
BE 10/07/15

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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July 7, 2010 10:29:15 AM

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Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 1.00

Required Qty: 1.00

D2620
Skidtube, 206 Skidtube

Manufactured No

Each 13.0000 1 1

Location

Loc Qty

Loc Code

LG

13

55559

3

57542

10

Each

81.0000

1

1

D2647
Cap

Manufactured No

Location

Loc Qty

Loc Code

FP

81

55352

81

Each

88.0000

19

19

D2649
Cross Bolt Spacer

Manufactured No

Location

Loc Qty

Loc Code

LG

88

58545

88

Each

0.0000

1

1

D2654-5
Web

Manufactured No

D2680-041
Nut Plate

Manufactured No

Each

44.0000

1

1

Location

Loc Qty

Loc Code

ST021

44

55366

44

July 7, 2010 10:29:15 AM

Shop Packet Print

Page 2

BE 10/07/07

BE 10/07/08

BE 10/07/15

B 605/6 (4) BE 10/07/13

BE 10/07/15

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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July 7, 2010 10:29:15 AM

Page 3

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Parent Item Name: Replacement Skidtube

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

220

Each

4,762.000

54

54



Insert

Location

Loc Qty

Loc Code

PKG11

4446

114723

4446

ST282

277

110511

38

114407

239

ST381

39

114654

39

AN960C10L

NAS1149C0332
R

Purchased

No

220

Each

0.0000

54

54



washer

2115000

AN960JD10L

NAS1149D0332J

Purchased

No

220

Each

3,301.000

2

2



Washer

Location

Loc Qty

Loc Code

ST348

3301

110985

3301

D2646

Manufactured

No

220

Each

97.0000

1

1



Aft Cap

Location

Loc Qty

Loc Code

FP-4

88

57332

88

FP6

9

52663

9

July 7, 2010 10:29:15 AM

Shop Packet Print

Page 3

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July 7, 2010 10:29:15 AM

Page 4

Work Order ID: 60411

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 1.00

Required Qty: 1.00

D2651-1 Manufactured No 220 Each 804.0000 14 14

 Plug

Location	Loc Qty	Loc Code
FP	208	
(51530)	208	
fpa	596	
53349	411	
57869	185	

x14 10/07/20

D2651-3 Manufactured No 220 Each 412.0000 14 14

 O-Ring

Location	Loc Qty	Loc Code
FP	412	
(46114)	412	

x14 10/07/20

D3535-11 Manufactured No 220 Each 11.0000 1 1

 Wearshoe

Location	Loc Qty	Loc Code
FP019	11	
(57261)	11	

x1 10/07/20

D3535-23 Manufactured No 220 Each 6.0000 1 1

 Wearshoe

Location	Loc Qty	Loc Code
FP21	6	
(57730)	6	

x1 10/07/20

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Page 4

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 5

Work Order ID: 60411

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 1.00

Required Qty: 1.00

D3535-35 Manufactured No

220 Each

8.0000

1 1



Wearshoe

Location

Loc Qty

Loc Code

FP018

8

59237

8

D3536-11 Manufactured No

220 Each

19.0000

1 1



Gasket

Location

Loc Qty

Loc Code

FP011

12

57867

12

ST497A

7

46649

3

46715

4

D3536-23 Manufactured No

220 Each

7.0000

1 1



Gasket

Location

Loc Qty

Loc Code

FP011

7

58819

7

D3536-35 Manufactured No

220 Each

12.0000

1 1



Gasket

Location

Loc Qty

Loc Code

FP012

12

58683

12

V 1 10/07/20

X 1 10/07/20

X 1 10/07/20

X 1 10/07/20

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 60411

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

220

Each

11.0000

6

6



Wearpad

Location

Loc Qty

Loc Code

FP

1

B59593

55465

1

FP17

3

57713

3

FP18

7

59710

7

D3537-3

Manufactured No

220

Each

21.0000

1

1



Wearpad

Location

Loc Qty

Loc Code

FP17

5

57512

5

FP19

16

59711

16

MS27039C1-08

~~MS27039-1-08~~

Purchased

No

220

Each

2,075.000

56

56



Screw

Location

Loc Qty

Loc Code

ST291

2075

110255

875

114718

200

115108

1000

★ SEE W/D CHG

X56

M 10/07/20

ATO

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.07.20	220	USE MS27039C1-08 / M19185 INSTEAD OF MS27039-1-08	JH	10/08/20	56	CP 10.07.20 05/04/2	S 10/08/20

Part No: D206-642-341 PAR #: _____ Fault Category: Prod eng coord. NCR: (Yes) No DQA: 7 Date: 10.08.05
 Resolution: Documentation raised Disposition: other. QA: N/C Closed: Ken Date: 10/08/06

NCR: 60411		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.07.20	220	IPP CALLS FOR MS27039-1-08, 11N CALLS FOR MS27039C1-08 R.C.L.A.:	CP 10.07.20 05/04/2	UPDATE IPP TO CALL FOR MS27039C1-08	EE 10.08.03	HA 10/08/03	CP 10.07.20 05/04/2	S 10/08/20

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 60411



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 7/07/10

Required Date: 7/14/10

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

220

Each

28.0000

1



Screw



Location

Loc Qty

Loc Code

ST292

28

28

109061

21 M 10/07/20

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

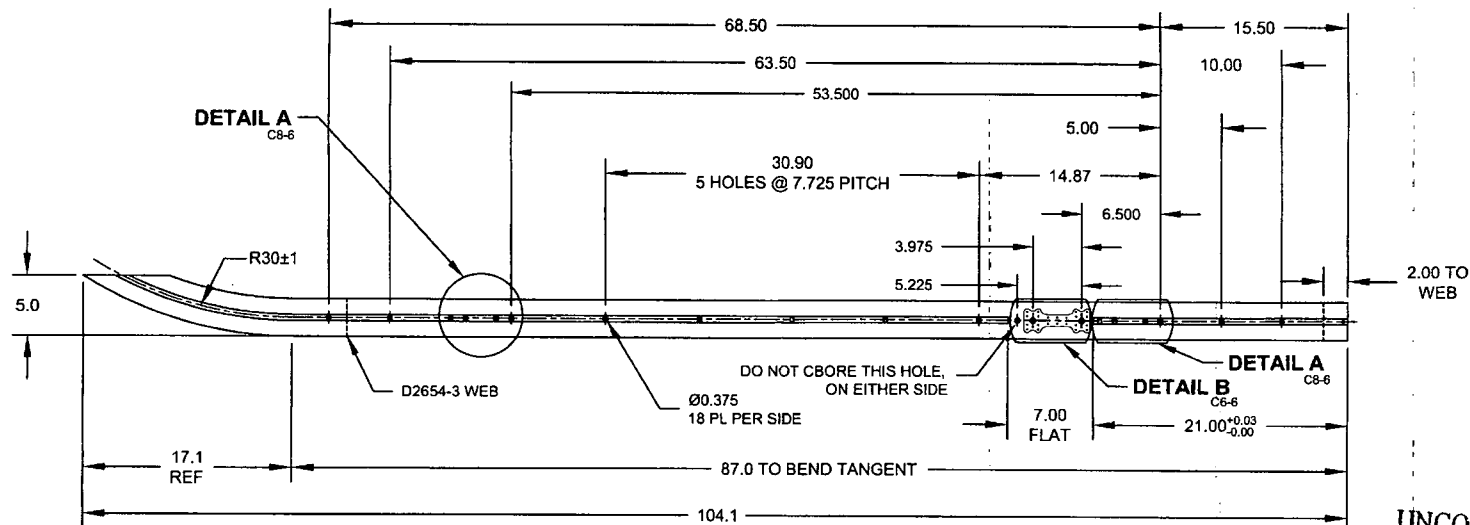
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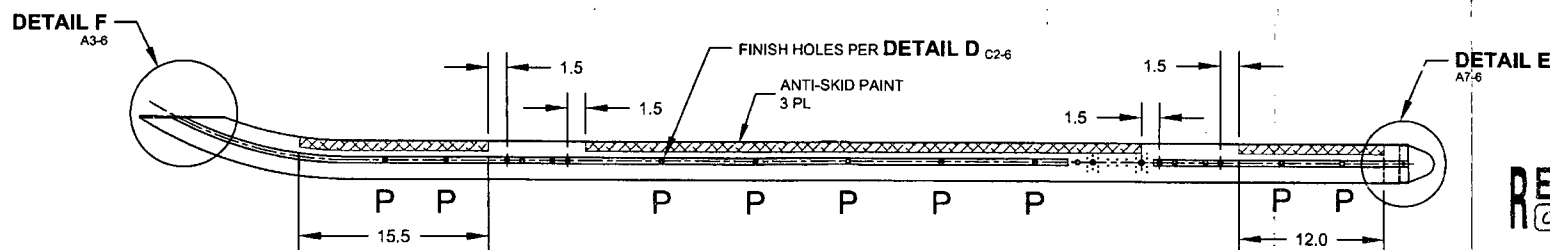
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F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	08.03.30
D	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
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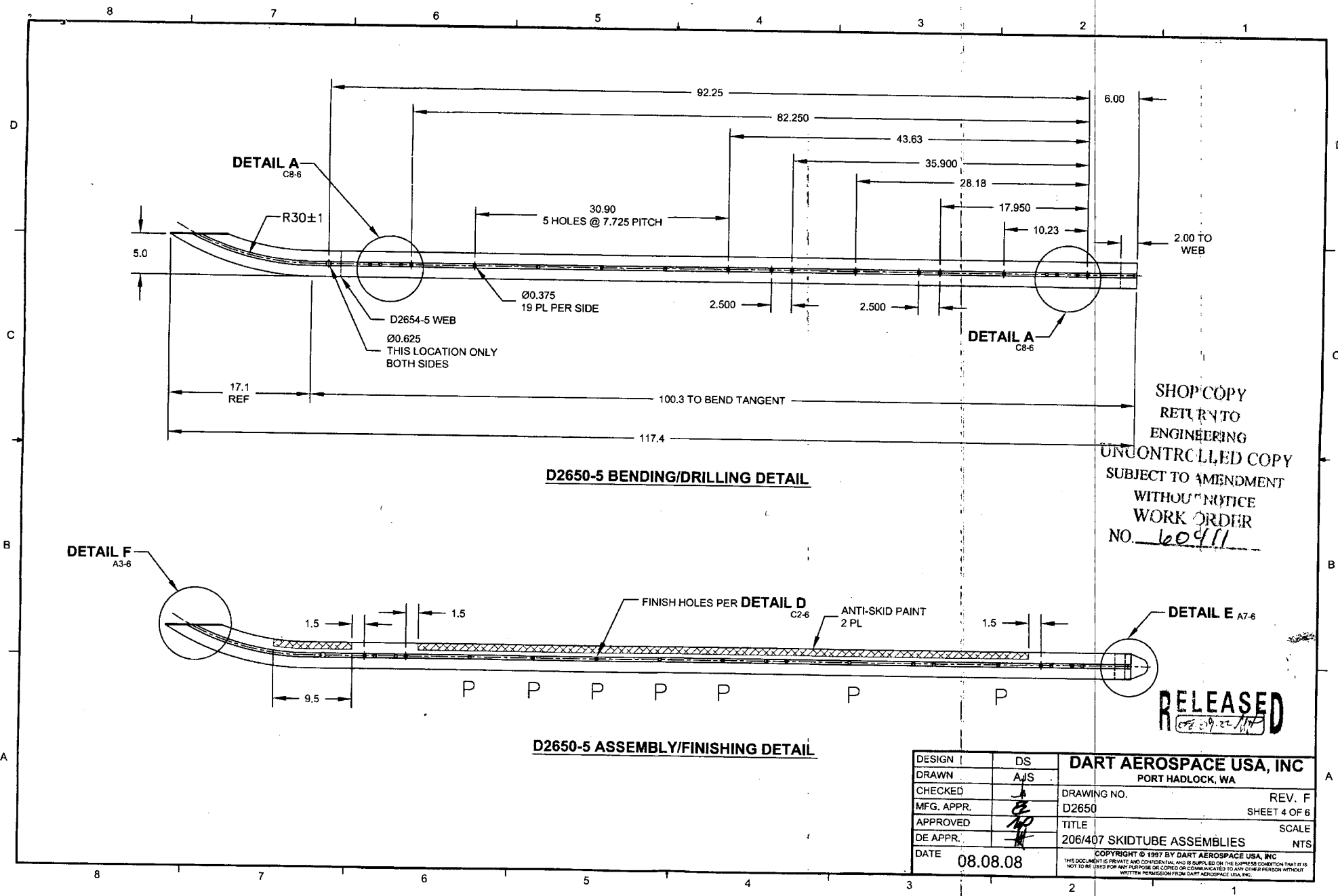
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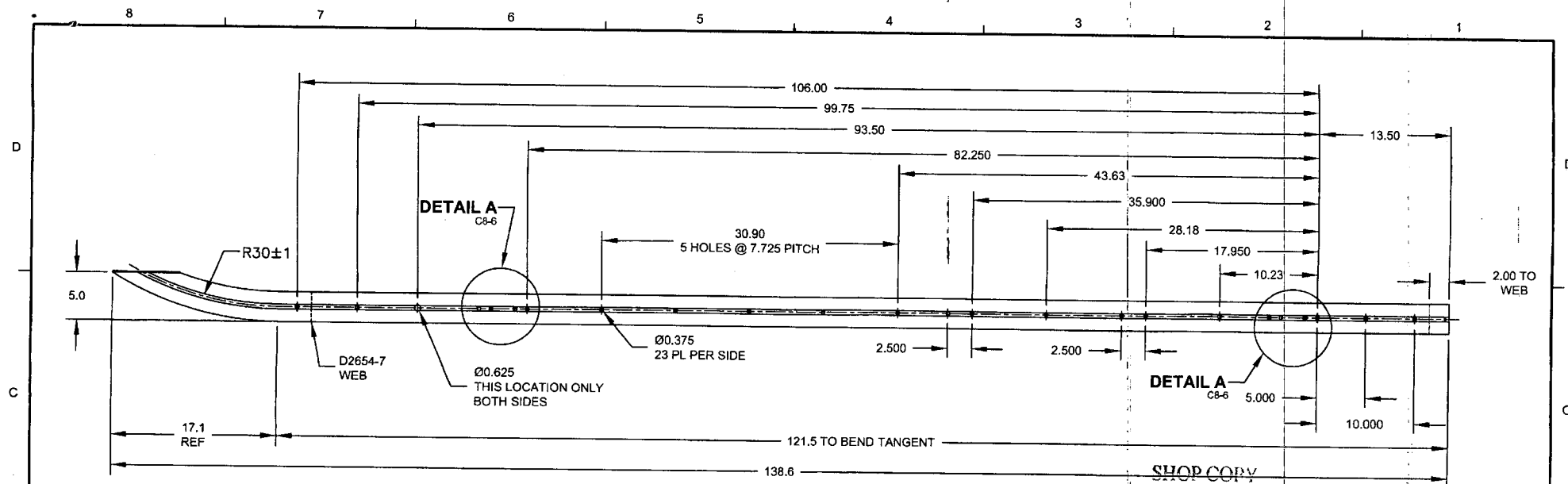
D2650-5 BENDING/DRILLING DETAIL

D2650-5 ASSEMBLY/FINISHING DETAIL

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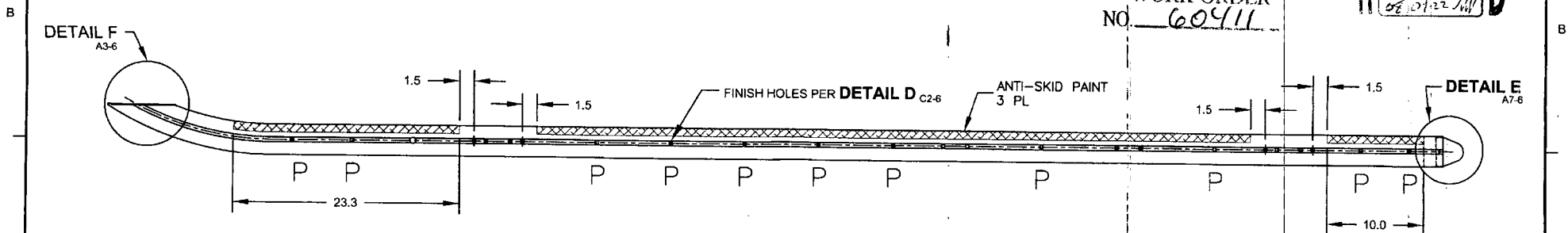
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D2650-7 BENDING/DRILL DETAIL

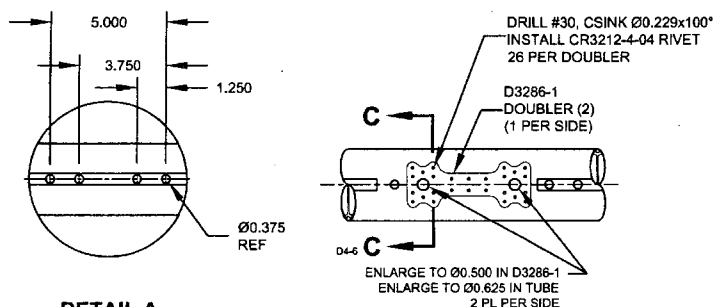
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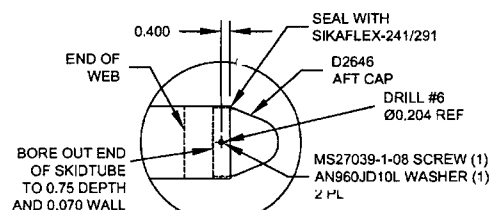
D2650-7 ASSEMBLY/FINISHING DETAIL

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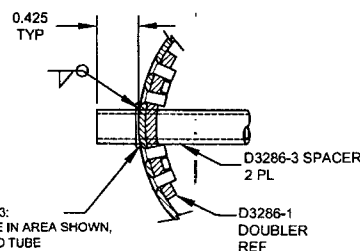
DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

DETAIL B
SCALE 2X
C3-2
C3-3

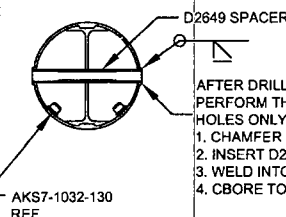


DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5

SECTION C-C C7-6
SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:

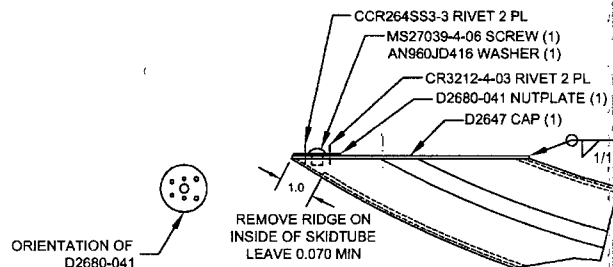
1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313 X 0.75 DP

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DETAIL F NOTES:


1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

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NO. 235

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Berley Elliott
Job number: 59780
Part number: D206-642-541
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier B. Elliott Date of Test Coupon 10.07.01

Welder Berley Elliott Date of Test Coupon 10.07.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG ⁽¹⁾
2B			14			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C6A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE
⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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